



Dart Aerospace Ltd.
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D2057

Job Sheet 195731



Part No: D2057

Job Qty: 10 pcs

Part Name: Plug



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/30/19

Job Tracking No:

Due Date: 6/7/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C IPP D 02.08.22 Make in Cobra KJ IPP Rev:E 08-05-27 as per ECN1195P DD verified by:EC IPP
Rev:F 08-06-04 Added QC8 JLM Verified By:EC IPP Rev:G 08-06-20 rev.D as per dwg DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Hardinge - 1	10 pcs	6/7/19	6/7/19	0.50	0.67	Hardinge - 1		BM.
120	QC 8	10 pcs	6/7/19	6/7/19	0.00	0.00	QC 8 - 12		In 19/07/11
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
130	Packaging 3-1 - Stock - B4B	10 pcs	6/7/19	6/7/19	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		



Container No: S197307



Part: D2057

Job No: 195731

Serial No/Batch: S197307

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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Date: 07/11/19

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				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	PC GA 126
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - SA	10 pcs	6/7/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	JUL 12 2019
				QC 21 - SA - 53	

DAS
70
9-89

Part Op **100** - Make as per Dwg D2057 and Folio FA260. Break all sharp edges 0.015 max. Do not drill Ø0.191
 Descriptions: **120** - (QC8- Inspect parts - second check)
130 - (Identify as per dwg & Stock Location: _____) LOCATION : GA
140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6R0.750	6061-T6 Round Bar .750"	1 ft (.1 ea)	100-Hardinge - 1	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Hardinge - 1	M6061T6R0.750	1	64	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Plug	1.150Inches $\pm$ 0.030	1.180 1.120		
2	Plug	0.150Inches $\pm$ 0.030	0.180 0.120		
3	Plug	0.750Inches $\pm$ 0.030	0.780 0.720		
4	Plug	0.030Inches $\pm$ 0.030	0.060 0.000		
5	Plug	45.000Degrees $\pm$ 0.000	45.000 45.000	Angle	
6	Plug	0.397Inches + 0.005 - 0.000	0.402 0.397		
7	Plug	0.150Inches $\pm$ 0.030	0.180 0.120	Radius	

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					